



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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D5149-9
Job Sheet 197783



Part No: D5149-9

Job Qty: 12 pcs

Part Name: Aft Step



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 7/16/19

Job Tracking No:

Due Date: 8/26/19

Created By: Manon Dubois

Type: SOLD

Description:

Note: DWG REV D SHEET 11 IPP REV:A NEW ISSUE 14-12-12 JLM VERIFIED BY:DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Bandsaw - 1	12 pcs	8/26/19	8/26/19	0.00	1.15	Bandsaw - 1		JML 14/07/24
115	HAAS 4 Axis - B4B	12 pcs	8/26/19	8/26/19	1.00	1.87	HAAS - 1 - B4B		JML 14/07/24
							HAAS - 2 - B4B		
							HAAS - 3 - B4B		
							HAAS - 4 - B4B		
120	QC 2	12 pcs	8/26/19	8/26/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		JML 17/07/24
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		



Container No: S200234



Part: D5149-9

Job No: 197783

Serial No/Batch: S200234

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 07/24/19

Dart Aerospace Ltd.
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CANADA
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				QC 2 - 8	
				QC 2 - 66	
				QC 2 - 64	
				QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	
130 QC 8	12 pcs	8/26/19	0.00 0.00	QC 8 - 12	=WK 19/07/25
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
				QC 8 - 52	
				QC 8 - 23	
				QC 8 - 57	
140 Packaging 3-1 - Stock - B4B	12 pcs	8/26/19	0.00 0.00	Packaging 3 - 1 - B4B	BL
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	

7/16/2019

[Dart Hawkesbury] Job Sheet - Dubois, Manon

				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
150 QC 21 - SA	12 pcs	8/26/19	0.00 0.00	QC 21 - SA - 21	
				QC 21 - SA - 70	
				QC 21 - SA - 53	

Part Op 110 - Bandsaw CUT BLANK AT 6.6.500" LONG
 Descriptions: 115 - HAAS CNC Vertical Machine - MILL AS PER DWG AND FOLIO FB344
 120 - QC2- Inspect parts off machine FAI/FAIB
 130 - QC8- Inspect parts - second check
 140 - Identify as per dwg & Stock LOCATION: WA001-13
 150 - QC21- Final Inspection - Work Order Release

DAS

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9-55

JUL 29 2019

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6T2.00W0.125	6061T6 Round Tube 2.00 X.125W	6.4920 ft (.541 ea)	110-Bandsaw - 1	5072328 = G-66 + 1.12

Job Allocations

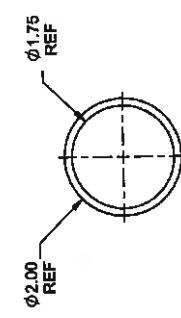
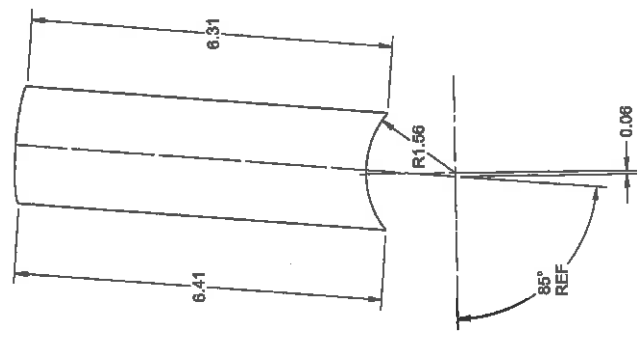
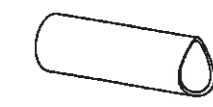
Operation	Component Part	Required	Inventory	Allocated
110-Bandsaw - 1	M6061T6T2.00W0.125	6	24	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Aft Step	2.000Inches	+ 0.012 - 0.001	2.012 1.999	
2	Aft Step	1.750Inches	+ 0.012 - 0.001	1.762 1.749	
3	Aft Step	6.310Inches	± 0.030	6.340 6.280	
4	Aft Step	6.410Inches	± 0.030	6.440 6.380	
5	Aft Step	1.560Inches	± 0.030	1.590 1.530	Radius

Plex 7/16/19 10:50 AM Dart.dart.int4

B 2 3 4 5 6 7 8



D5149-9 AFT STEP

NOTES:
 1) MATERIAL: 6061-T6/T62/T6510/T6511 SEAMLESS TUBING PER WW-T-700/6 OR QQ-A-200/8 OR QQ-A-225/8 OR AMS 4080 OR AMS 4082 OR AMS 4083 OR ASTM B210 OR ASTM B241
 REF DART SPEC M6061T6T2.000W0.125

- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.006 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.44 lbs

RELEASED
 2015-11-04

APPROVED

DESIGN	DB	DART AEROSPACE LTD
DRAWN	AP	HAWKSBURY, ONTARIO, CANADA
CHECKED	DB	DRAWING NO. D5149
MFG. APPR.	DD	REV. D SHEET 11 OF 11
APPROVED	WM	TITLE STEP ASSEMBLY
DE APPR.	DS-4	SCALE NTS
DATE	15.10.20	COPYRIGHT © 2014 BY DART AEROSPACE LTD

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